

Work Order ID 110069  
December-17-13 9:07:29 AM

D3407-041  
B110069

\*110069\*

Page 1

Item ID: D3407-041

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Tow Ring

Start Date: 12/17/13 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 12-12-19

Tooling:

Date:

Run Start

\*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3407	Rev E

100 Large Fab 0.00

\*100\*

Large Fab

Memo

0.00

Large Fab

Weld D3407-1/-5 using welding rod TIG174 as per Dwg D3407 & QSI 004  
A/R TIG174 ROD Batch: M102576

x8 14-01-22 MAL

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

\*110\*

QC

Memo

0.00

Quality Control

⑧ 14-01-23

DAS  
9  
9-89

120 QC5- Inspect part completeness to step on W/O 0.00

\*120\*

QC

Memo

0.00

Quality Control

⑧ 14-01-23

DAS  
9  
9-89

811008  
12-12-61

# Work Order ID 110069

December-17-13 9:07:29 AM

**\*110069\***

Page 2

Item ID: D3407-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Tow Ring  
 Start Date: 12/17/13 Start Qty: 8.00 **\*g\*** Cust Item ID:  
 Required Date: 12/17/13 Req'd Qty: 8.00 **\*g\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M 126879</i> Memo **Mask Threaded Section** START TIME: <i>1:30</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>2:00</i>	0.00  0.00				<i>8</i>	<i>0</i>	<i>14-1-23</i>	DAS 34 9-89
140 <b>*140*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				<i>8</i>			DAS 27 9-89 <i>M 1124</i>
150 <b>*150*</b> Packaging Packaging	Identify as per dwg & Stock Location: <i>ST463</i>  Memo	0.00  0.00				<i>8x</i>		<i>14-01-24</i>	DAS 28 9-89

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\*110069\*

Page 3

Item ID: D3407-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Tow Ring

Start Date: 12/17/13 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

\*160\*

QC

Memo

0.00

Quality Control

MLJ 14-01-27

① 14-01-24

# Picklist Print

December-17-13 9:07:29 AM

Page 1

Work Order ID: 110069  
 Parent Item: D3407-041  
 Parent Item Name: Tow Ring

Start Date: 12/17/13 Required Date: 12/17/13  
 Start Qty: 8.00 Required Qty: 8.00

Comments: IPP Rev:A05.10.14New issueKJ/EC  
 IPP Rev:B 08-09-09 revE as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3407-1 Stem		Manufactured	No			100	Each	28.0000	1	8			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA001	28	
103869	6	
109128	21	
92142	1	

x8

14-10-22 MAL

D3407-5  
 Ring

Manufactured No 100 Each 21.0000 1 8

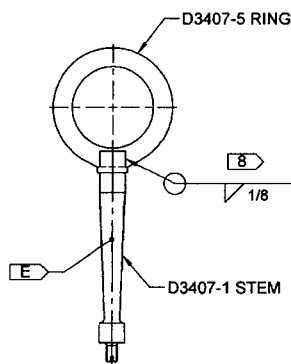
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA001	21	
107660	21	

x8

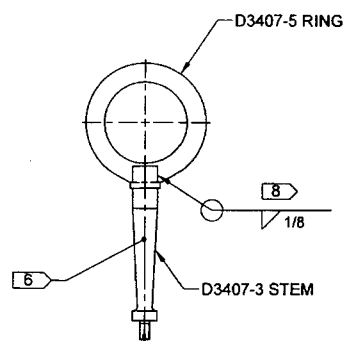
14-01-22 MAL

B 108467 x 3

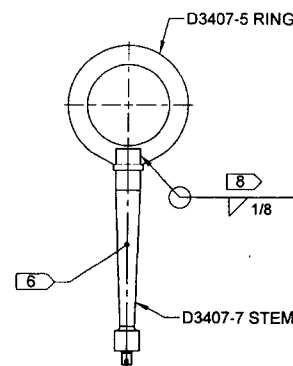
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM



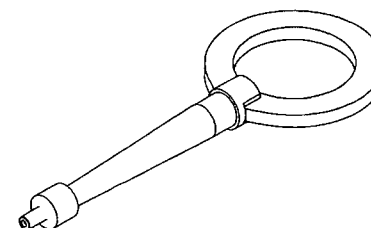
**D3407-041 TOW RING**



**D3407-043 TOW RING**



**D3407-045 TOW RING**



**RELEASED**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

REV.	DESCRIPTION	BY	DATE
E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/-3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/-3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/-3 LONGER FOR FIT W/WASHER	CP	05.09.08
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.23		

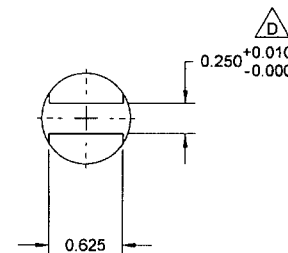
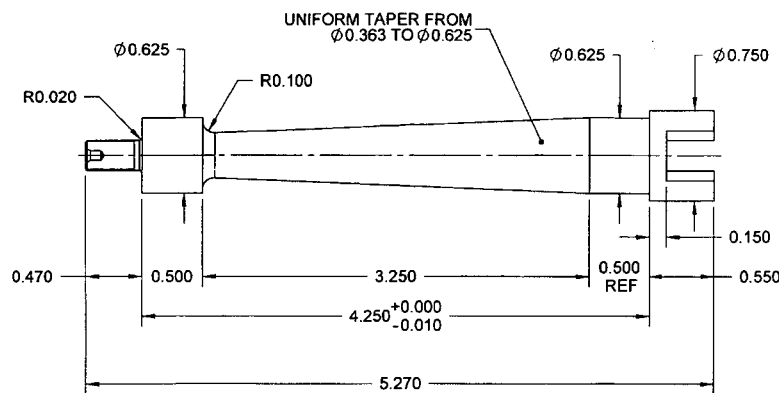
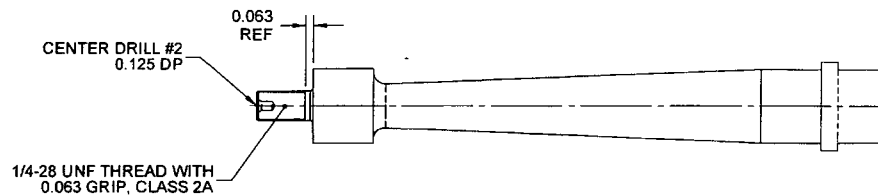
**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

DRAWING NO. **D3407**  
REV. E  
SHEET 1 OF 5

TITLE **TOW RING**  
SCALE  
NTS

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110069 MLT  
1312-19

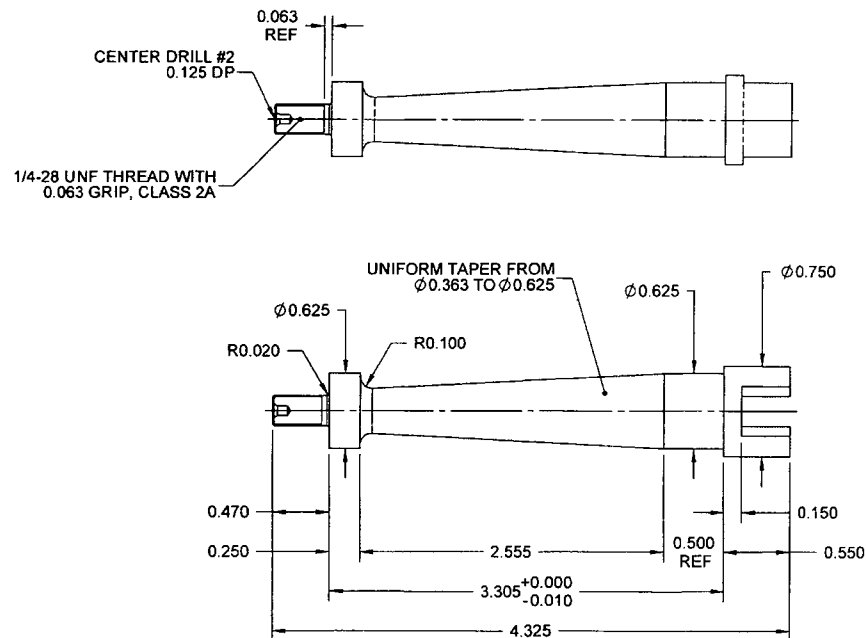


# **D3407-1 STEM**

**RELEASED**

- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.33 lbs

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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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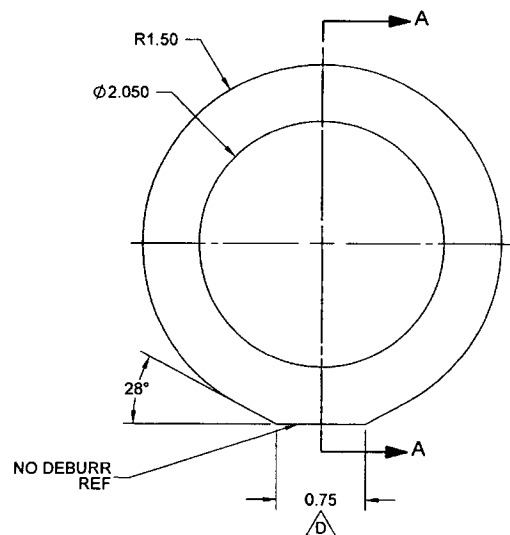
**D3407-3 STEM**

- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.27 lbs

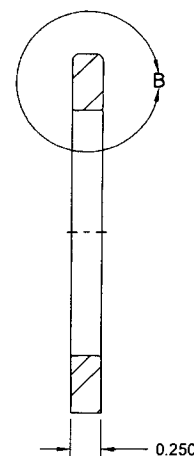
**RELEASED**  
08-08-01 N/A

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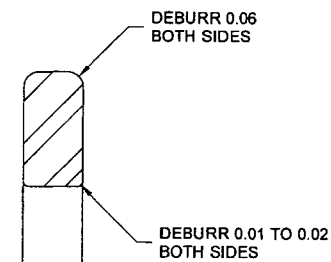
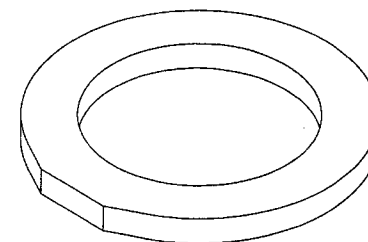




**D3407-5 RING**



**SECTION A-A**



**DETAIL B  
SCALE 2X**

**RELEASED**  
08-06-01/11/11

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.27 lbs

DESIGN	92	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	1/16	PORT HADLOCK, WA	
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MFG. APPR.		D3407	SHEET 4 OF 5
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